

Date: Tuesday, 1/2/2007 1:27:46 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 30095	Part Number	: D2572
Estimate Number	: 10531	Drawing Number	: D2572 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 1/2/2007	Drawing Revision	: E
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 1/9/2007
Previous Run	: 29661	Qty:	12
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number: .



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>325352</u> <u>X12</u> <u>Ep 07/01/02</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B 30095</u> Double check by: <u>J.F.</u> <u>RF</u>
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		 Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 <u>SC/EP 07/01/09</u> <u>12</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/01/06	# 30	I (one) part affected. Key way cut to width at far left skid tube hole o.777" instead of o.765; only that area affected. Rest of the keyway is o.765"	J QSI W2	Part was fitted onto a skid tube. Part acceptable	GT 07/01/06	J 07/01/06	J QSI W2	J 07/01/06
		moved in the wrong direction during set up.						

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: SDDate: 06/01/12

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 1/2/2007 1:27:46 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30095

Part Number: D2572

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SF for 07/01/09 (12)</i>
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>J.F. 07/01/10 (12)</i>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1	<i>R 07/01/10 x12</i>
	Acid etch and Alodine as per QSI 005 4.1	
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING	<i>i02391</i>
	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	<i>FJL 07/07/11 (12)</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	<i>R 07/01/12 (12)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	<i>EBS 08/02/12 (12) PD 7/07/12</i>
	Identify and Stock Location: 38472	
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>07/01/12 (12)</i>

Job Completion



U 07.01.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	30075
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	-2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.501	3.500		
D	1.745	1.755		1.750	1.750	1.749	1.748		
E	7.990	8.010		7.999	8.002	8.002	8.001		
F	0.490	0.510		0.501	0.493	0.496	0.496		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.494	0.496	0.495	0.494		
J	1.174	1.184		1.174	1.174	1.174	1.174		
K	0.558	0.578		0.561	0.566	0.565	0.560		
L	1.174	1.184		1.174	1.174	1.174	1.176		
M	1.490	1.500		1.492	1.493	1.494	1.492		
N	2.495	2.505		2.498	2.497	2.499	2.499		
O	3.869	3.879		3.870	3.871	3.870	3.871		
P	0.115	0.135		0.126	0.124	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.248	0.248	0.249		
S	0.115	0.135		0.118	0.120	0.124	0.123		
T	0.178	0.198		0.182	0.188	0.188	0.188		
U	2.940	2.980		2.940	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.236	0.234	0.236		
W	0.115	0.135		0.125	0.120	0.126	0.126		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.370	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.623	0.623	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.246	0.250	0.244		
AE	1.375	1.395		1.384	1.390	1.386	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.249	0.245	0.244	0.245		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	JP	Audited by:	JL
Date:	07/01/08	Date:	07/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK

DART AEROSPACE LTD	Work Order:	30075
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.503	.503	.503	.503		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.125	.125	.125	.125		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.370	.370	.370	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.386	1.386	1.386	1.386		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	TSG /EP	Audited by:	J.F.
Date:	07.01.10	Date:	07/01/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM

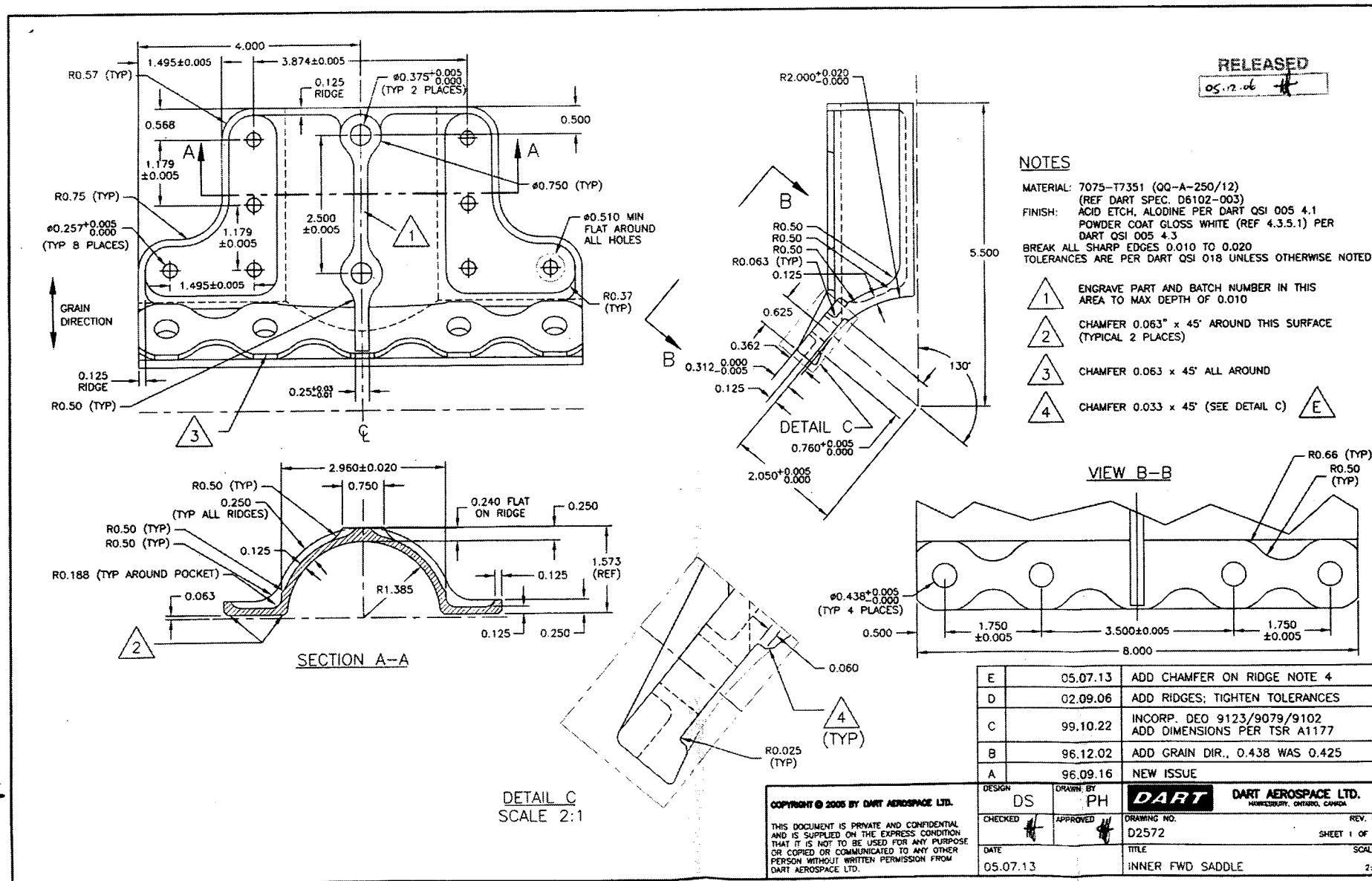
DART AEROSPACE LTD				Work Order:	30095
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.749	1.749	1.749	1.750		
C	3.495	3.505		3.499	3.501	3.501	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.750		
E	7.990	8.010		8.004	8.001	8.001	8.003		
F	0.490	0.510		0.491	0.496	0.499	0.495		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.498	0.495	0.494	0.499		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.563	0.569	0.569	0.567		
L	1.174	1.184		1.177	1.175	1.177	1.177		
M	1.490	1.500		1.493	1.494	1.496	1.491		
N	2.495	2.505		2.500	2.498	2.498	2.498		
O	3.869	3.879		3.873	3.873	3.873	3.876		
P	0.115	0.135		0.123	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.242	0.250	0.250	0.251		
S	0.115	0.135		0.116	0.120	0.121	0.111		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.230	0.232	0.230	0.236		
W	0.115	0.135		0.123	0.123	0.123	0.121		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.624	0.624	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.245	0.246	0.246		
AE	1.375	1.395		1.389	1.387	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.242	0.242	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	Ep	Audited by:	J.F.
Date:	07/01/09	Date:	07/01/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM



COMMERCIAL FROM THE STATE AUTOMOTIVE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MACKENZIE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2572
DATE	TITLE	SCALE
05.07.13	INNER FWD SADDLE	2:1